

Date: Monday, 6/18/2007 2:01:08 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BALL
Job Number : 32925	
Estimate Number : 12508	
P.O. Number : <i>NA</i>	Part Number : D35211
This Issue : 6/18/2007 S.O. No. : <i>NA</i>	Drawing Number : D3521 UNDER REVIEW
Prsht Rev. : NC	Project Number : 1A0001
First Issue : <i>NA</i> Type : PURCHASED PARTS	Drawing Revision : UNDER REVIEW
Previous Run : 32190	Material : <i>NA</i>
Written By : _____	Due Date : 6/25/2007 Qty: 3 Um: Each
Checked & Approved By : _____	
Comment : EST A 06.08.21 NEW ISSUE EC	

Additional Product

POSITIVE RECALL
 EFFECTIVE *07.06.18* AUTH *LL*
 RELEASED _____ DATE _____

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: _____

Purchase Part Number: 9617K47

Supplier: MCMASTER

Certificate of conformity is required

2.0 *9617K47* *D3521-1* BALL*batch: B32190*

Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

BALL

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Drill & Tap hole as per dwg D3521 using indexing fixture.

2- Deburr & polish, ensure no flat spot created from clamping.

3- Install Heli-coil.

*Rework as per attached Dwg.**07.06.18*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL

Job Number: 32925

Part Number: D35211

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21209F115

HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

HELI COIL

batch: 104537

MS 07/06/19

3

7.0

QC5 CB 07.06.21

INSPECT PARTS AS THEY COME OFF MACHINE



ENGINEERING
APPROVAL



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Not Required

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/26

07/06/26

Job Completion



POSITIVE RECALL

EFFECTIVE _____

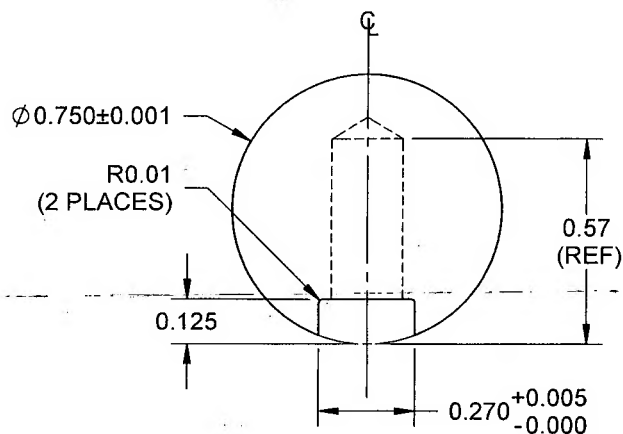
AUTH _____

RELEASED H

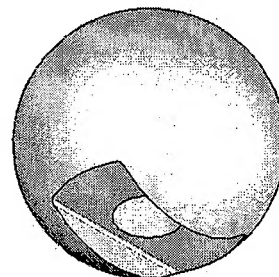
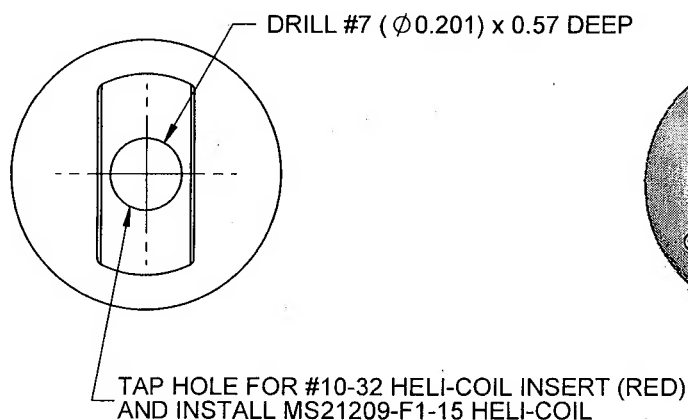
DATE 07/06/26

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3521	REV. A SHEET 1 OF 1
DATE 07.06.14	TITLE BALL		SCALE 2:1
REV A	DATE 07.06.14	DESCRIPTION NEW ISSUE	



REFERENCE ONLY



PRELIMINARY ISSUE

D3521-1 BALL

NOTES:

- 1) MATERIAL: BRASS $\phi 0.75$ BALL (CAN MAKE FROM McMASTER-CARR P/N 9617K47)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015
- 6) PART IS SYMMETRIC ABOUT ϕ

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